

Date:
User:Thursday, 3/9/2006 12:44:26 PM
Kim Johnston

Process Sheet

SPLIT-1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUBBLE WINDOW, RH
Job Number	: 26192	Part Number	: D32692
Estimate Number	: 11394	Drawing Number	: UNDER REVIEW D3269
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 3/9/2006 S.O. No. : N/A	Drawing Revision	: B
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Due Date	: 3/16/2006 Qty: 5 Um: Each
Previous Run	: 26083		
Written By	: <u>See COMMENT Below</u>		
Checked & Approved By	: <u>06.03.09</u>		
Comment	: Est. A0503/22 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O:

Manufacture D3269-2 as per Dwg D3269

Possible Supplier: Canus

Material release note is required

773

u 06.03.09

2.0 D32692P Bubble Window, RH R44

Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Bubble Window, RH R44

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

C 06/04/17

①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/04/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
060417	4	A small scratch was found on the inside corner of the window, from supplier, or shipping.	AB 060417	Polish out scratch using step 1, 2, 3, then polish for plastic.	AB 06/17/18	AB 060417	AB 060417	AB 060417

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUBBLE WINDOW, RH

Job Number: 26192

Part Number: D32692

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/04/18

Job Completion



u 06-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

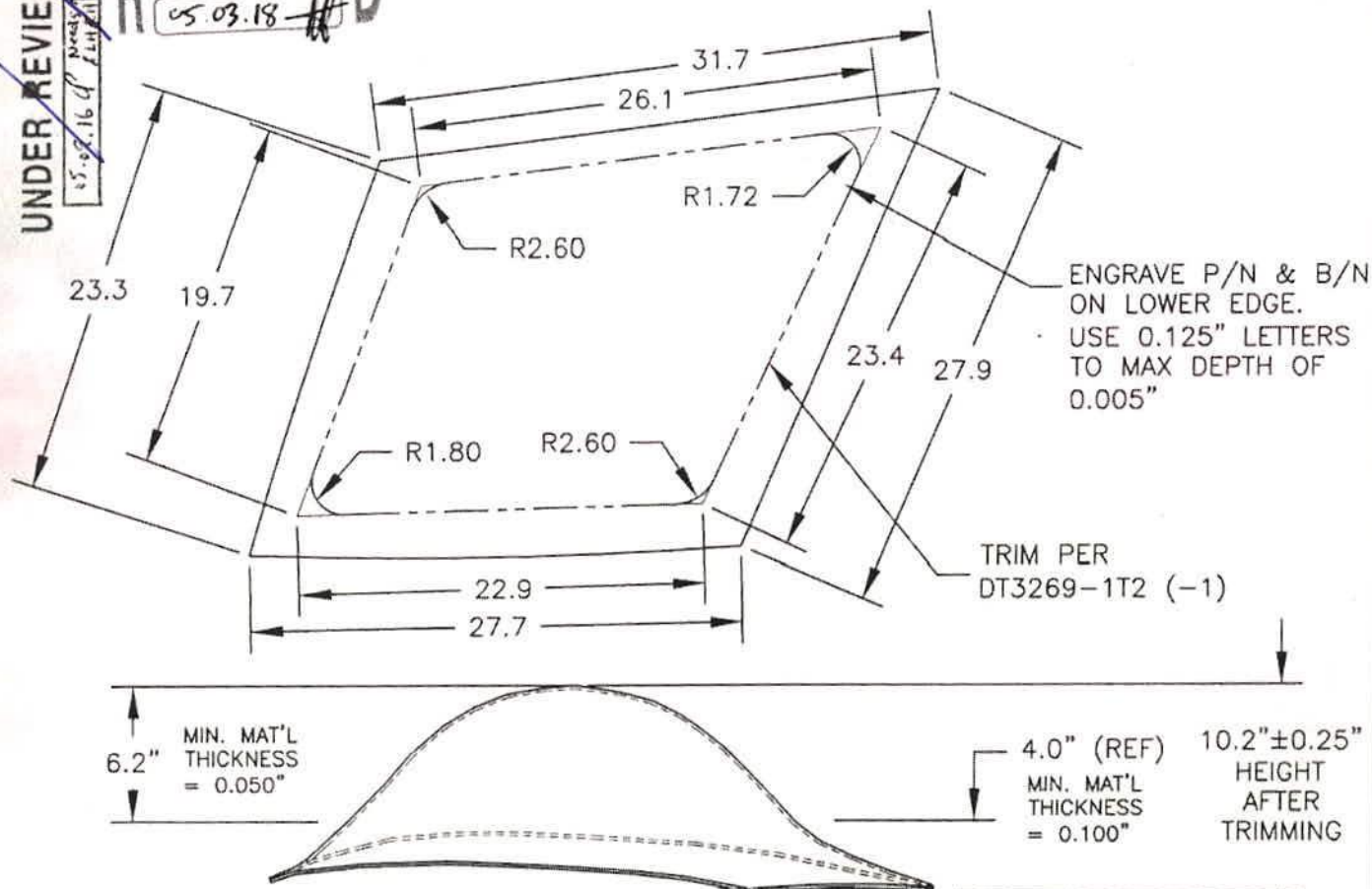
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART*OK for this batch
CP 05.03.10*

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3269
DATE	05.03.10	TITLE	BUBBLE WINDOW (R44)	REV. B SHEET 1 OF 1
A	05.02.18	NEW ISSUE		SCALE 1:10
B	05.03.10	UPDATE MATERIAL SPEC.		

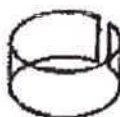
UNDER REVIEW**RELEASED**
05.03.18 *[Signature]***D3269-1 BUBBLE WINDOW, LH (SHOWN) / D3269-2 BUBBLE WINDOW, RH (OPPOSITE)**

- 1) FORM PER D3269-1T1 (-1) OR D3269-2T1 (-2)
FORMING PROCESS: (a) DRAPE OVER D3269-1T1/-2T1 MOLD
(b) HEAT TO 250°F
(c) VACUUM FORM TO SPECIFIED HEIGHT
(d) LEAVE FOR AT LEAST 20 MINUTES COVERED WITH INSULATED BLANKETS TO COOL
- 2) TRIM PER TEMPLATE D3269-1T2 (-1) OR D3269-2T2 (-2)
- 3) MATERIAL: PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.188 TH.
MINIMUM THICKNESS AFTER FORMING AS SHOWN ABOVE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WORK ORDER
NO. 26192

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CNUS Plastics Inc.

300 LISGAR ST
OTTAWA, ONTARIO
K2P 0E2
PH: 613-232-2657
FAX: 613-232-6214

Certificate of Conformance

Date: 12/09/05

To: DART AEROSPACE
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

P.O.#: 773

Order# 124780

The undersigned hereby certifies that the materials supplied and the items shipped under the above purchase order, are in conformance with, all applicable specifications and/or purchase order requirements. All reports of the materials supplied are on file and can be made available upon request.

<u>Quantity</u>	<u>Description</u>	<u>Specification</u>
1	BUBBLE WINDOW,RH	DWG # D3269-2

SIGNED: _____

CANUS PLASTICS INC.
300 Lisgar Street
Ottawa, ON
K2P 0E2

Phone: 613 232 2657
info@canusplastics.com
www.canusplastics.com

Fax: 613 232 6214

Order Confirmation 124780

CUSTOMER NO. 163233

BILL TO: DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

SHIP TO: SAME

Attn: Accounts Payable

(613)632-3336

DATE	SHIP VIA	PO/B	TERMS
04/11/06	Pick up	Our Dock	Net 30 days

PO NUMBER	ORDER DATE	SALES PERSON
773	04/11/06	TM

PART NUMBER	DESCRIPTION	QUANTITY REQUIRED	UNIT PRICE	EXTENDED PRICE
MFG	D-3269-2 BUBBLE WINDOW	1	249.00	249.00

Net amount	249.00
Discount	
G.S.T.	17.43
Shipping	
Total due:	=====
	266.43